

Date: Tuesday, 12/20/2005 9:56:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412698019 - RTN 420
Job Number	: 25279		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D412698019
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D412698019
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/16/2005 Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: <u>Est Rev C RP</u>	Due Date	: 12/23/2005
Checked & Approved By	: <u>See above</u>	Qty:	2 Um: Each
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



*2005-12-20*

Comment: INSPECT RTN 420

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 PACKING KIT

3.0	D312121	Bolt
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Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)  
 Bolt *B 24224*

4.0	D3121241	Bearing Assembly
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Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s)  
 Bearing Assembly *B 25057 x 16 / B 25225 x 4*

5.0	D31373	Guide
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Guide *B 18660*

6.0	D31375	Washer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Washer *m10536-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 02/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:56:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412698019 - RTN 420

Job Number: 25279

Part Number: D412698019

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bearing Assembly

B23974

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw

m11735

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
INSPECT KIT FOR COMPLETENESS  
RE-PACKAGE PER PPP

C2 06/01/11 (2)

Rev A / 06/01/11 (2)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
INSPECT LEVEL 21

54C 06/01/13 (2)

SP 06/01/13 (2)

Job Completion



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bearing Overhaul Kit		<b>Part Number:</b>	<b>D412-698-019</b>
<b>Dwg:</b> N/A		<b>Qty:</b>	<b>Kit(s)</b>
<b>Ref:</b> IIN-D412-698 Rev. C page 10		<b>Page 1 of 1</b>	

Step	Location	Procedure	By	Date	Qty																												
1	DC	Issue Traveler																															
2	DC	Photocopy bluefile and create labels per PPP D412-698-019 <b>CHG001</b>																															
3	KP	<b>Pick: Packing Kit</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>7</td><td>D3121-21</td><td>Bolt</td><td>B24224</td></tr><tr><td>5</td><td>D3121-241</td><td>Bearing Assembly</td><td>B25057</td></tr><tr><td>1</td><td>D3137-3</td><td>Guide B 18660</td><td><del>B20098</del></td></tr><tr><td>1</td><td>D3137-5</td><td>Washer</td><td>M10536-17</td></tr><tr><td>2</td><td>D3183-045</td><td>Bearing Assembly</td><td>B23974</td></tr><tr><td>1</td><td>MS24694-S101</td><td>Screw</td><td>M11735</td></tr></tbody></table>	Qty	Part Number	Description	Batch	7	D3121-21	Bolt	B24224	5	D3121-241	Bearing Assembly	B25057	1	D3137-3	Guide B 18660	<del>B20098</del>	1	D3137-5	Washer	M10536-17	2	D3183-045	Bearing Assembly	B23974	1	MS24694-S101	Screw	M11735			
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1	D3137-5	Washer	M10536-17																														
2	D3183-045	Bearing Assembly	B23974																														
1	MS24694-S101	Screw	M11735																														
4	QC4	Inspect Kit 100% for Completeness on the W/O	CV	06/01/11	2																												
5	PK	Identify and pack for shipping as per PPP D412-698-019 <b>REV A</b>	CV	06/01/11	2																												
6	AC	Cost / part: _____																															
7	DC	Close W/O Inspect Level 21																															

Rev	Date	Change	Revised By	Approved
A	03.11.27	New issue	KJ/RF	
B	05.10.12	Pick List revised	KJ/JLM	

REFERENCE ONLY

## 6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
						7	D3121-21	BOLT
						5	D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
						1	D3137-3	GUIDE
						1	D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
						2	D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1			1			D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
			12				AN960JD10L	WASHER
		8					AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
		8					MS21042L4	NUT (OR MS21042-4)
		16					MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

REFERENCE ONLY

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Revision: C

Date: 04.02.18

Bill of Materials Listing

Dart Aerospace Ltd.  
Hawkesbury

Dec 20, 2005  
09:15 am

Bill Of Materials Name : 698-019  
Product Code : \*D412-698-019  
Product/Bom Description : Bearing Overhaul Kit  
Last Edited : 10-12-05

Revision Number :  
Mfg Quantity : 1  
Batch Quantity : 1

Listing All Items

Lev	Part Number Reference 1	Amount	Part Description Reference 2	Manufacturer & Part No
1	D3121-21	7.000	Bolt	
1	D3121-241	5.000	Bearing Assembly	
1	D3137-3	1.000	Guide	
1	D3137-5	1.000	Washer	
1	D3183-045	2.000	Bearing Assembly	
1	MS24694-S101	1.000	Screw	

REFERENCE ONLY

4/08

2

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20275
<b>Description:</b> Bearing Overhaul Kit	<b>Part Number:</b>	D412-698-019
<b>Dwg:</b> N/A	<b>Qty:</b>	4 Kit(s)
<b>Ref:</b> IIN-D412-698 Rev. B page 10		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																				
1	DC	Issue Traveler F04.01.16	[Signature]	04.01.22	4																																				
2	DC	Photocopy bluefile and create labels per PPP D412-698-019 CHG001 ML 6 [Signature]	[Signature]	04.02.03	4																																				
3	KP	<b>Pick: Packing Kit</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>8</td><td>D3121-17 ✓</td><td>Washer</td><td>m10536-17</td></tr><tr><td>6</td><td>D3121-19 ✓</td><td>Bearing B20097</td><td>B19992</td></tr><tr><td>1</td><td>D3137-3 ✓</td><td>Guide</td><td>B20098</td></tr><tr><td>1</td><td>D3137-5 ✓</td><td>Washer m10536-17</td><td>B30-23000-209</td></tr><tr><td>3</td><td>D3183-5 ✓</td><td>Bearing</td><td>B19939</td></tr><tr><td>1</td><td>D3183-7 ✓</td><td>Washer</td><td>B18987</td></tr><tr><td>8</td><td>MS24694-S50 ✓</td><td>Screw</td><td>m14206</td></tr><tr><td>1</td><td>MS24694-S101 ✓</td><td>Screw</td><td>m11735</td></tr></tbody></table>	Qty	Part Number	Description	Batch	8	D3121-17 ✓	Washer	m10536-17	6	D3121-19 ✓	Bearing B20097	B19992	1	D3137-3 ✓	Guide	B20098	1	D3137-5 ✓	Washer m10536-17	B30-23000-209	3	D3183-5 ✓	Bearing	B19939	1	D3183-7 ✓	Washer	B18987	8	MS24694-S50 ✓	Screw	m14206	1	MS24694-S101 ✓	Screw	m11735	[Signature]	04.01.27	4
Qty	Part Number	Description	Batch																																						
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1	D3183-7 ✓	Washer	B18987																																						
8	MS24694-S50 ✓	Screw	m14206																																						
1	MS24694-S101 ✓	Screw	m11735																																						
4	QC4	Inspect Kit 100% for Completeness on the W/O	[Signature]	04.02.03	4																																				
5	PK	Identify and pack for shipping as per PPP D412-698-019	[Signature]	04.02.03	4																																				
6	AC	Cost / part 89.89	[Signature]	04.02.04	4																																				
7	DC	Close W/O 89.89 Inspect Level 21	[Signature]	04.02.05	4																																				

Rev	Date	Change	Revised By	Approved
A	03.11.27	New issue	KJ/RF	[Signature]

BB 04-02-04 [Signature]

return to stock

D3121-19 B20097 x12

D3183-5 B19939 x6

D3121-17 m10536-17 x16

D3183-7 B18987 x2

m1524694-S50 m14206 x16

RELEASED

03.12.05 [Signature]